

Work Order ID 144106

April 04, 2016 2:08:37 PM

144106

Page 1

Item ID: D3180-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Strut Assembly, RH

Stop ***NS2***

Start Date: 5/6/2016 Start Qty: 1.00

***4* 2 84**
***4* 2**

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: SLADate: 20160405 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3180

C

100

0.00

100

NC BRAKE

Brake NC

Memo

0.01

Brake NC

1-Punch Tubing to length as per Dwg D3180-2 using DT8313, DWG D2638

2FFMAY 05 2016

110

0.00

110

Small Fab

Small Fab

Memo

0.03

Small Fab

1-Drill holes as per Dwg D3180

2-Bend strut as per Dwg D3180

3-Deburr edges

2FFMAY 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144106

144106

Page 2

April 04, 2016 2:08:37 PM

Item ID: D3180-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Assembly, RH
 Start Date: 5/6/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/24/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(2)			DAS 38 9-89 MAY 06 2016
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 134631 Memo START TIME: 2:25 OVEN TEMPERATURE: 400 FINISH TIME: 2:55	0.00 0.02					2	6 16-05-12	2 34 9-89
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(2)			DAS 38 9-89 MAY 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Page 3

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Small Fab					2	FF		
Small Fab	Memo	0.01							MAY 16 2016
Small Fab	1-Assemble as per Dwg D3180								
160		0.00							
160	QC5- Inspect part completeness to step on W/O	0.00				2			
QC	Memo	0.00							
Quality Control									DAS 38 8-88 MAY 17 2016
170		0.00							
170	Identify as per dwg & Stock Location: <u>St320</u>	0.00							
Packaging	Memo	0.00				2			
Packaging									DAS 38 8-88 MAY 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 144106***144106***

Page 4

Item ID: D3180-042

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Strut Assembly, RH

Stop

NS2

Start Date: 5/6/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

16/5/19 

MCS MAY 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

Picklist Print

April 04, 2016 2:08:41 PM

Page 1

Work Order ID: 144106

144106

Parent Item: D3180-042

D3180-042

Parent Item Name: Strut Assembly, RH

Start Date: 5/6/2016

Required Date: 5/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.04.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6		Manufactured	No				Each	18.0000		1			
D2690-6									**		FF	MAY 16 2016	
Lanyard													

Location	Loc Qty	Loc Code
ST009	6	
142782	6	
ST012a	12	
142876	12	

M304TR0.750W.065

Purchased

No

f

136.2814

3.771895

M304TR0 750W 065

**

MAY 05 2016

304 RD Tube .750 x .065W

Location	Loc Qty	Loc Code
GA002	136.2814	
114002	10	
118390	2	
m129493	124.2814	

D2022-101

Manufactured

No

Each

95.0000

2

D2022-101

**

MAY 16 2016

Spacer

Location	Loc Qty	Loc Code
ST001	49	
132703	49	
ST012a	46	
140201	46	

Picklist Print

April 04, 2016 2:08:41 PM

Page 2

Work Order ID: 144106

144106

Parent Item: D3180-042

D3180-042

Parent Item Name: Strut Assembly, RH

Start Date: 5/6/2016

Required Date: 5/24/2016

Start Qty: 1.00

Required Qty: 1.00

A1449

Purchased

No

Each

1,059.000

1

A1449

Grommet

FF

MAY 16 2016

Location

Loc Qty

Loc Code

ST548

1059

1487

1059

2

MS17984-C310

Purchased

No

Each

3.0000

1

MS17984-C310

Quick Release Pin

FF

MAY 16 2016

Location

Loc Qty

Loc Code

ST315

3

134509
m132852

3

2

MS21042L3

Purchased

No

Each

2,067.000

1

MS21042L3

Nut

FF

MAY 16 2016

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

798

m133790

6

m134360

792

2

Return2016

1

M132382

1

ST304

1168

m134039

12

m134360

1156

Picklist Print

April 04, 2016 2:08:41 PM

Page 3

Work Order ID: 144106

144106

Parent Item: D3180-042

D3180-042

Parent Item Name: Strut Assembly, RH

Start Date: 5/6/2016

Required Date: 5/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

Each

568.0000

1

MS27039-1-10

FF

MAY 16 2016

SCREW

Location

Loc Qty

Loc Code

CA

41

m128635

41

GA

18

m129541

18

over 006

300

m134567

300

ST280

209

m134370

209

2

NAS1149D0363J

Purchased

No

Each

2,280.000

3

NAS1149D0363.J

FF

MAY 16 2016

Washer

Location

Loc Qty

Loc Code

GA

598

m134055

598

Return2016

2

m132317

2

ST260a

1000

m134606

1000

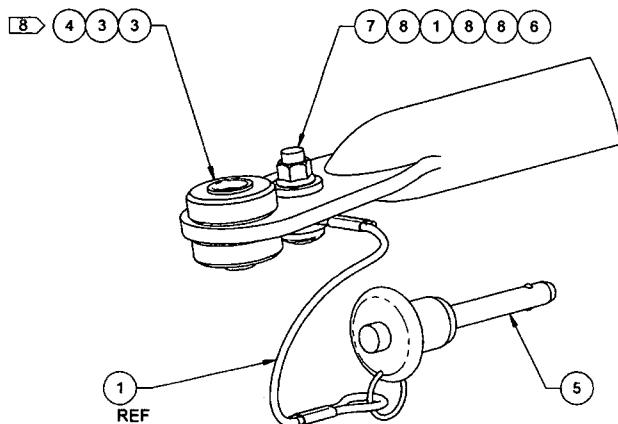
ST263

680

m134370

680

6



DETAIL A
SCALE 3X

D3180-041 STRUT ASSEMBLY, LH

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3180-041	STRUT ASSEMBLY, LH
1	1	D2690-6	LANYARD
2	1	D3180-1	STRUT
3	2	D2022-101	SPACER
4	1	A1449	GROMMET
5	1	MS17984-C310	PIN, QUICK RELEASE
6	1	MS21042L3	NUT, SELF-LOCKING
7	1	MS27039-1-10	SCREW, PAN-HEAD
8	3	NAS1149D0363J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3180-041" AND BATCH NUMBER PER QSI 044 6.1
- 7) WEIGHT: 1.86 lbs
- 8) SWAGE D2022-101 SPACERS ONTO D3180-1 STRUT USING A1449 GROMMET

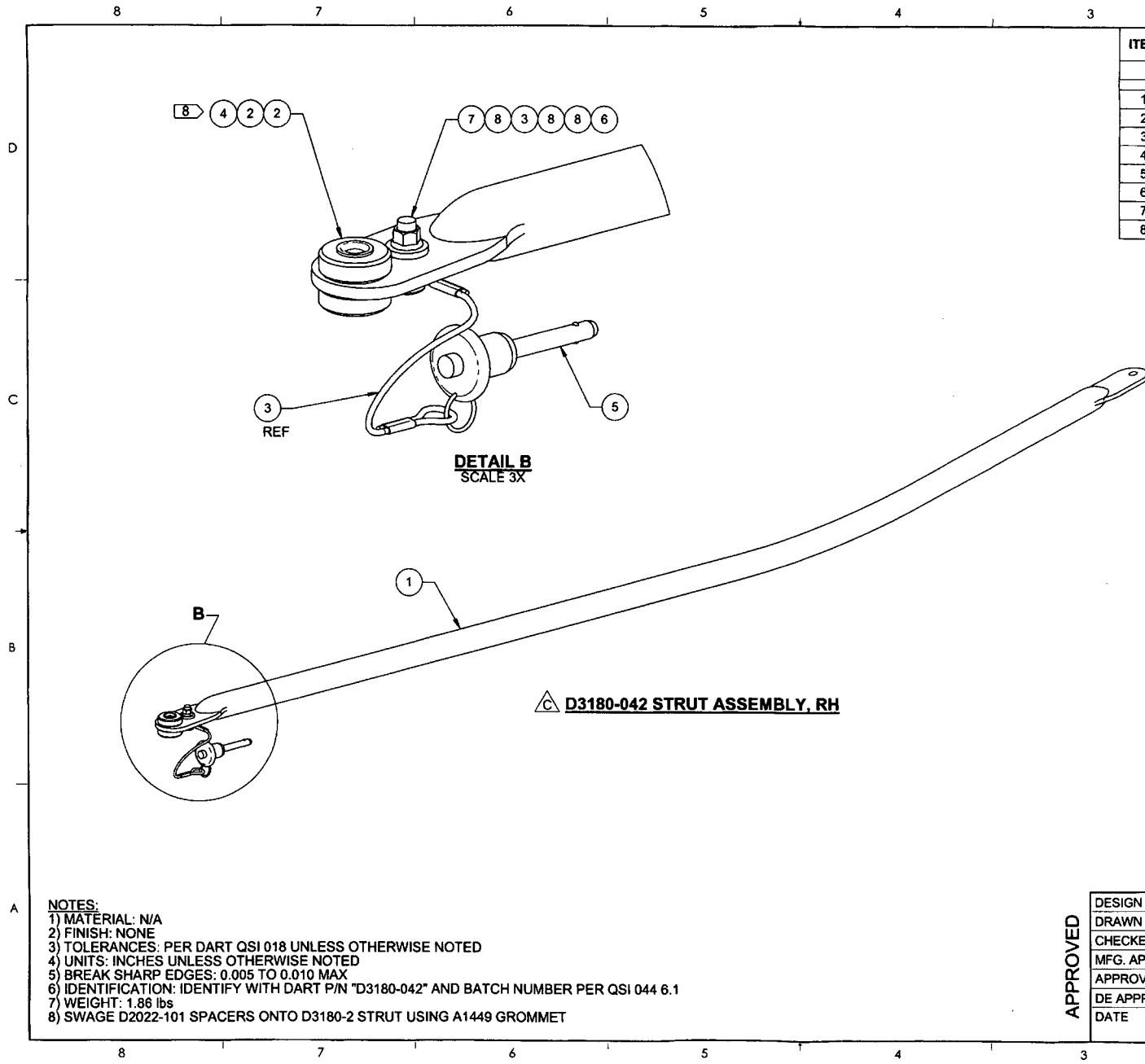
20160405

SA 144106

RELEASED
2014-10-04

C	ADD D3180-042/-2 (SHEETS 2 AND 4).	REF: NCR14-3457.	MB	14.03.24
B	CURVE ADDED		DC	07.05.23
A	NEW ISSUE		RF	03.01.06
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	MB			
CHECKED	AP	DRAWING NO.	REV. C	
MFG. APPR.	JLM	D3180	SHEET 1 OF 4	
APPROVED	MP	TITLE	SCALE	
DE APPR.	DS	STRUT ASSEMBLY	NTS	
DATE	14.03.24	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

APPROVED



DETAIL B
SCALE 3X

D3180-042 STRUT ASSEMBLY, RH

ITEM	QTY -042	P/N	DESCRIPTION
	X	D3180-042	STRUT ASSEMBLY, RH
1	1	D3180-2	STRUT
2	2	D2022-101	SPACER
3	1	D2690-6	LANYARD
4	1	A1449	GROMMET
5	1	MS17984-C310	PIN, QUICK RELEASE
6	1	MS21042L3	NUT, SELF-LOCKING
7	1	MS27039-1-10	SCREW, PAN-HEAD
8	3	NAS1149D0363J	WASHER

NOTES:

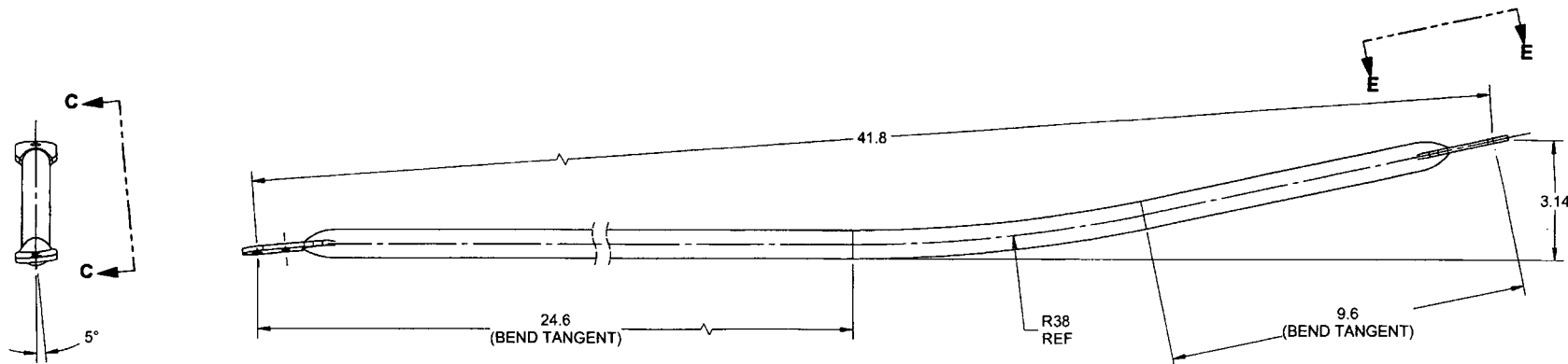
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3180-042" AND BATCH NUMBER PER QSI 044 6.1
- 7) WEIGHT: 1.86 lbs
- 8) SWAGE D2022-101 SPACERS ONTO D3180-2 STRUT USING A1449 GROMMET

APPROVED

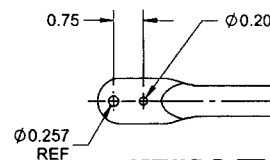
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3180	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	14.03.24	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-10-04

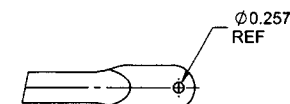
mp



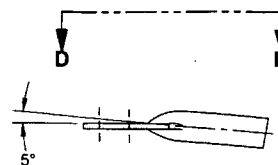
D3180-1 STRUT



VIEW D-D 8



VIEW E-E 8



VIEW C-C

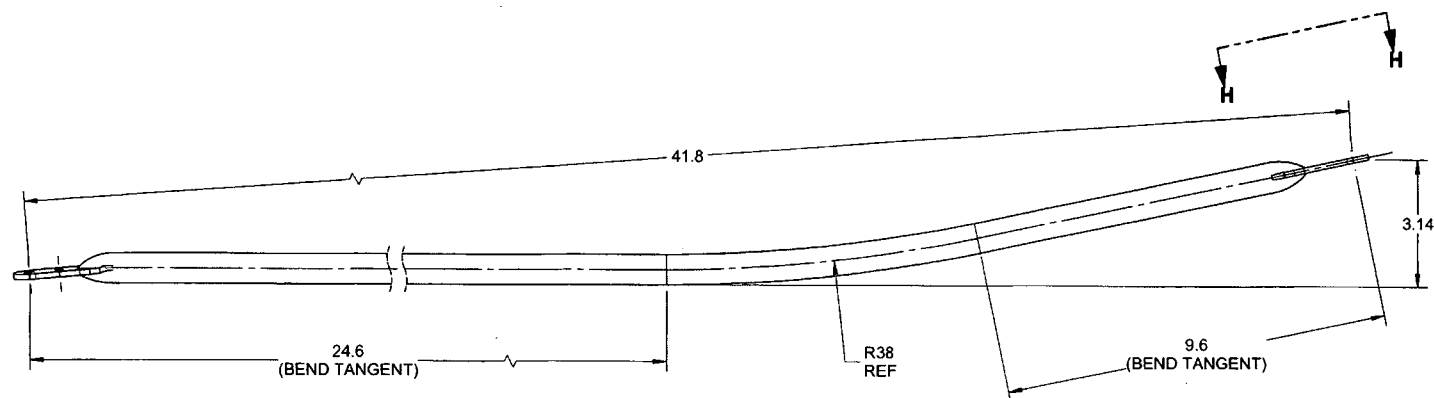
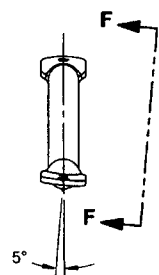
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 $\phi 0.75 \times 0.065$ WALL, PER ASTM A213 OR ASME SA213 OR ASTM A269
 REF. DART SPEC. M304TR0.750W.065
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.82 lbs
- 8) PUNCH: PER SPEC. CONTROL DWG D2638

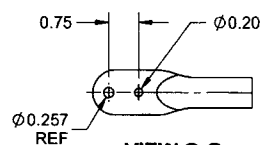
RELEASED
 2014-10-04

APPROVED

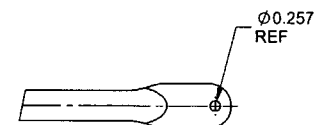
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3180	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	14.03.24	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



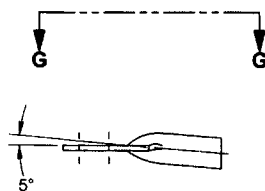
D3180-2 STRUT



VIEW G-G



VIEW H-H



SECTION F-F

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 $\phi 0.75 \times 0.065$ WALL, PER ASTM A213 OR ASME SA213 OR ASTM A269
 REF. DART SPEC. M304TR0.750W.065
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.82 lbs
- 8) PUNCH: PER SPEC. CONTROL DWG D2638

RELEASED
 2014-10-04

APPROVED

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3180	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	14.03.24	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	